

82037

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 22/03/2012 **Start Qty:** 16.00

16

Cust Item ID:

Required Date: 05/04/2012 **Req'd Qty:** 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/22 Tooling:

Date:

Run Start *NR1*

QC: _____

Date: **SPC (Y/N):**

Date:

Stop *NR2*

| | |
|-----------------|---------------------|
| Draw Nbr | Revision Nbr |
| D3405 | Rev B |

0.00

100

FLOW WATER JET

0.00 AB12-4-8

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3405

304.125

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 82037

82037

Page 2

March-22-12 10:31:21 AM

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 22/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-------------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Brake NC Brake NC | NC BRAKE Memo 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming | 0.00 0.00 | | | | (17) | ✓ | | |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | SB 12/04/10 | | (17) | | | |
| 150 *150* Large Fab Large Fab | Weld per dwg A/R S.S. rod Batch: <u>M120013</u> Large Fab Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-043 | 0.00 0.00 | | | | (17) | | EL 12-4-12 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 82037

March-22-12 10:31:21 AM

Flash & Lp today
82037

Page 3

Item ID: D3405-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Lug Assembly
Start Date: 22/03/2012 Start Qty: 16.00 *16* Cust Item ID:
Required Date: 05/04/2012 Req'd Qty: 16.00 *16* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | | | | |
| *160* | | | | | | 17x | Ø | | Cpl 12.04.13 |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 180 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| Powdercoat | | | | | | | | | |
| Powder Coating | | | | | | | | | |

Memo
START TIME: 8:45
OVEN TEMPERATURE: 400 °F
FINISH TIME: 9:15

M120222

17x Ø *M-L* *12/04/13*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 82037

82037

Page 4

March-22-12 10:31:21 AM

Item ID: D3405-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 22/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 *190* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 17 | 1 | BL12-4-12 | |
| 200 *200* Packaging Packaging | Identify as per dwg & Stock Location: 547 Memo | 0.00 0.00 | | | | 17x | | SP 12-04-13 | |
| 210 *210* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | 12/4/17 | |

01204/16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

March-22-12 10:31:24 AM

Page 1

Work Order ID: 82037

82037

Parent Item: D3405-043

D3405-043

Parent Item Name: Lug Assembly

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP A05.09.01New issueKJ/JLM

IPP B 09.01.28 Rev b dwg EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3404-1 | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 16 | | | |
| *D3404-1* | | | | | | | | | ** | | | | |
| GHW Lug | | | | | | | | | | | | | |
| M304S11GA | | Purchased | No | | | 150 | sf | 51.0000 | 0.154 | 2.593684 | | | |
| *M304S11GA* | | | | | | | | | ** | | | | |
| 304/316 0.125 Sheet | | | | | | | | | | | | | |

Location

MAT020

120243

121070

Loc Qty

51

19

32

Loc Code

121070

17

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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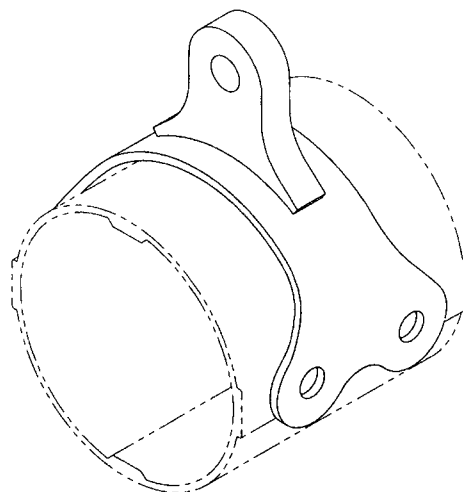
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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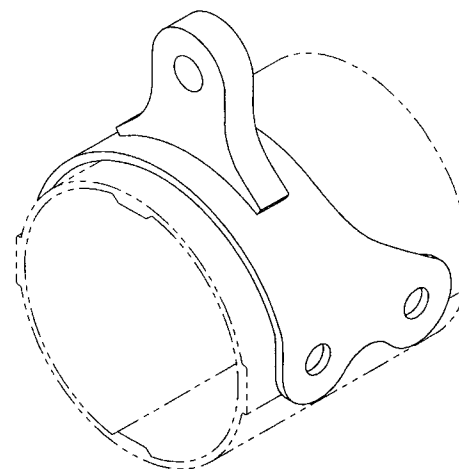
NOTE: Date & initial all entries

| ITEM No. | QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|-----------|-----------|-------------|--------------|
| 1 | X | | D3405-041 | LUG ASSEMBLY |
| 2 | | X | D3405-043 | LUG ASSEMBLY |
| 11 | 1 | 1 | D3404-1 | GHW LUG |
| 12 | 1 | | D3405-1 | GHW BRACKET |
| 13 | | 1 | D3405-3 | GHW BRACKET |

△



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)




SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82037465

12/03/22

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

| | | | | |
|------------|---|--|--------------|----------|
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. | | AJS | 08.09.19 |
| A | NEW ISSUE | | PH | 05.03.08 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | AJS | | | |
| CHECKED |  | DRAWING NO. | REV. B | |
| MFG. APPR. |  | D3405 | SHEET 1 OF 4 | |
| APPROVED |  | TITLE | SCALE | |
| DE APPR. | | GHW LUG ASSEMBLY | NTS | |
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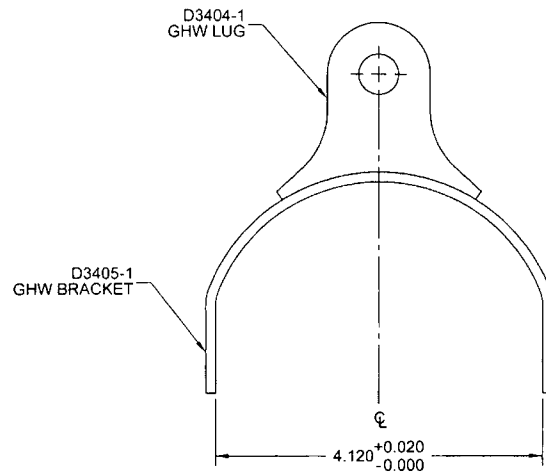
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

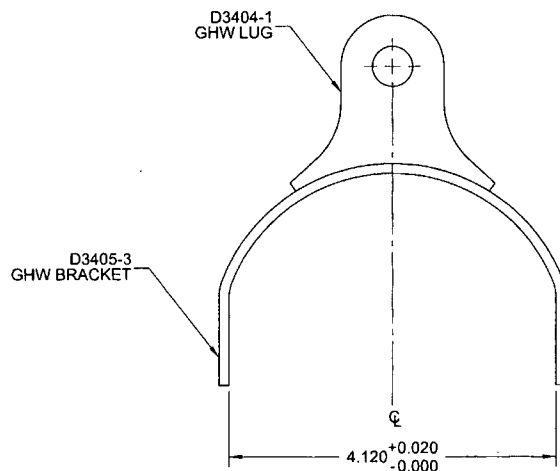
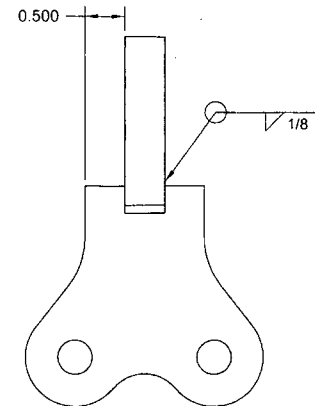
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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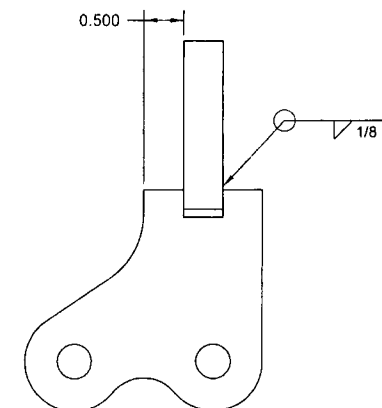
NOTE: Date & initial all entries



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



82037

RELEASED
06/12/18

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|------------|----------|--|------------------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. D3405 | REV. B SHEET 2 OF 4 |
| MFG. APPR. | | TITLE GHW LUG ASSEMBLY | SCALE NTS |
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| DE APPR. | | | |
| DATE | 08.09.19 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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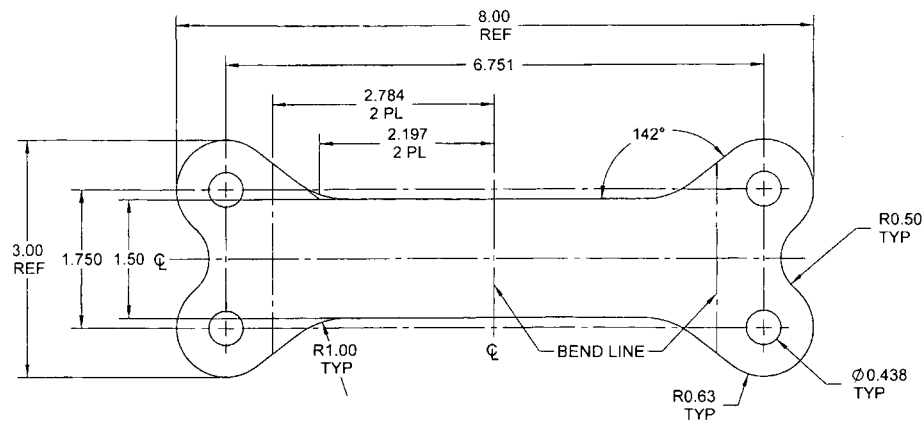
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

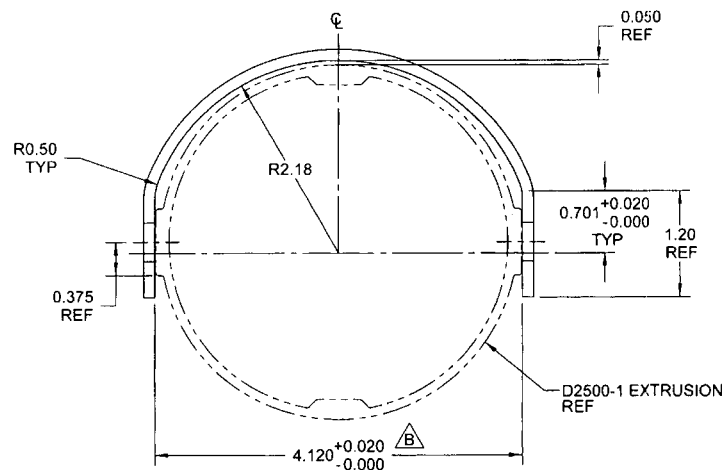
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

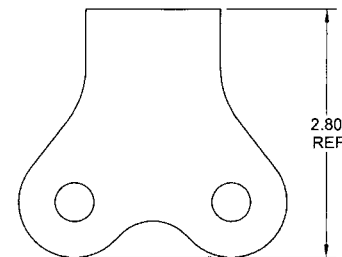
82037



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
07/08/12

| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
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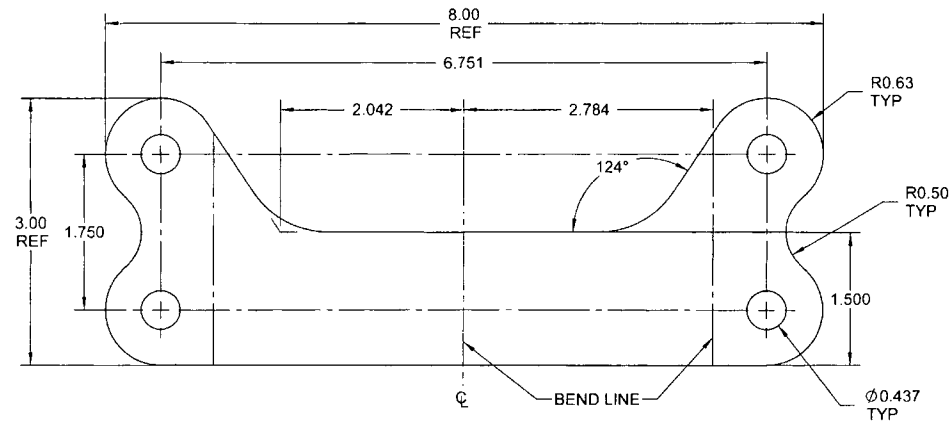
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

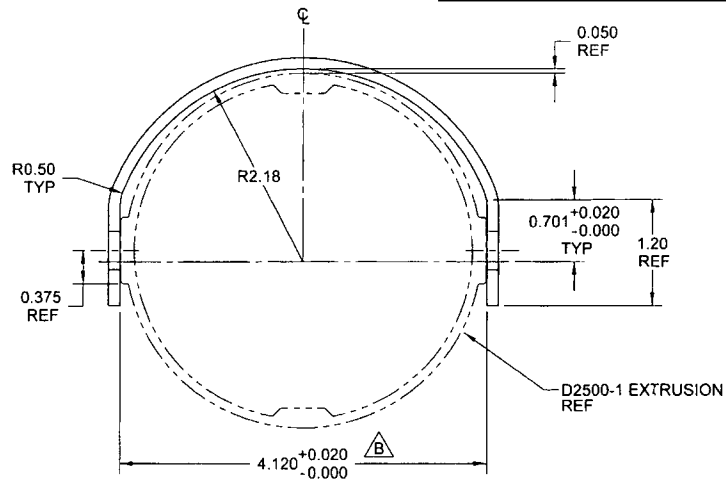
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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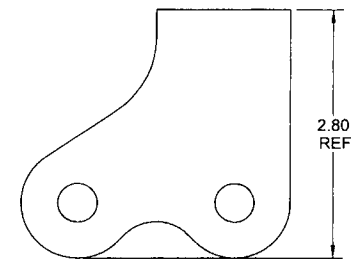
NOTE: Date & initial all entries



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
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08/12/18 NW

02037

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries